

# Work Order ID 65945

Thursday, January 27, 2011 1:26:06 PM

ASAP  
SHIP next  
week 1/2



Page 1

Item ID:	D3574-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Cabin Floor Protector					
Start Date:	1/27/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	1/31/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-01-27	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3574	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3574 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2- Deburr if necessary								

1311-1-27

①

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

1311-1-27

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

Sulu/28

⊗

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 65945**

Thursday, January 27, 2011 1:26:06 PM



Page 2

Item ID: D3574-2

Revision ID:

Item Name: Cabin Floor Protector

Start Date: 1/27/2011 Start Qty: 1.00

Required Date: 1/31/2011 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

Deburr if necessary.

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/128

④

150



Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

Memo

0.00

0.00

11/02/02

11.02.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 65945**

Thursday, January 27, 2011 1:26:06 PM



Page 3

Item ID: D3574-2

Revision ID:

Item Name: Cabin Floor Protector

Start Date: 1/27/2011 Start Qty: 1.00

Required Date: 1/31/2011 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/02/02

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, January 27, 2011 1:26:12 PM

Page 1

Work Order ID: 65945

Parent Item: D3574-2

Parent Item Name: Cabin Floor Protector

Start Date: 1/27/2011

Required Date: 1/31/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F60029-04 Purchased No



GE PLASTICS LEXAN SHEET

sf 3,548.678 33.61681



B11-1-27

Location

MAT

Loc Qty

3548.6788

Loc Code

115261

892.6788

116236

2656

116236

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	63945
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b>	D3574-2
<b>Inspection Dwg:</b> D3574 <b>Rev:</b> B		<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.002	✓		V B62	
7.37	+/-0.030	7.37	✓		T B01	
10.75	+/-0.030	10.75	✓		T	
11.00	+/-0.030	11.00	✓		T	
15.25	+/-0.030	15.25	✓		T	
25.87	+/-0.030	25.87	✓		T	
39.75	+/-0.030	39.75	✓		T	
44.75	+/-0.030	44.75	✓		T	
53.51	+/-0.030	53.51	✓		T	
63.50	+/-0.030	63.50	✓		T	
65.25	+/-0.030	65.25	✓		T	
10.75	+/-0.030	10.75	✓		T	
11.00	+/-0.030	11.00	✓		T	
14.75	+/-0.030	14.75	✓		T	
25.50	+/-0.030	25.50	✓		T	
25.75	+/-0.030	25.75	✓		T	
26.00	+/-0.030	26.00	✓		T	
32.87	+/-0.030	32.87	✓		T	
38.81	+/-0.030	38.81	✓		T	
45.00	+/-0.030	45.00	✓		T	
48.25	+/-0.030	48.25	✓		T	
58.38	+/-0.030	58.38	✓		T	
61.25	+/-0.030	61.25	✓		T	
64.13	+/-0.030	64.13	✓		T	
64.63	+/-0.030	64.63	✓		T	
66.50	+/-0.030	66.50	✓		T	
7.50	+/-0.030	7.50	✓		T	
9.50	+/-0.030	9.50	✓		T	
10.38	+/-0.030	10.38	✓		T	
10.88	+/-0.030	10.88	✓		T	
14.50	+/-0.030	14.50	✓		T	
16.56	+/-0.030	16.56	✓		T	
18.75	+/-0.030	18.75	✓		T	
24.13	+/-0.030	24.13	✓		T	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	115945
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b>	D3574-2
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> B	<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	26.50	X		T HB01	
30.50	+/-0.030	30.50	4		T	
33.88	+/-0.030	33.88	4		T	
39.50	+/-0.030	39.50	4		T	
40.25	+/-0.030	40.25	4		T	
43.50	+/-0.030	43.50	X		T	
46.60	+/-0.030	46.60	X		T	
7.63	+/-0.030	7.63	X		T	
11.00	+/-0.030	11.00	*		T	
11.50	+/-0.030	11.50	*		T	
16.75	+/-0.030	16.75	*		T	
19.00	+/-0.030	19.00	*		T	
22.50	+/-0.030	22.50	*		T	
30.75	+/-0.030	30.75	X		T	
32.63	+/-0.030	32.63	4		T	
32.75	+/-0.030	32.75	*		T	
35.13	+/-0.030	35.13	*		T	
36.50	+/-0.030	36.50	X		T	
40.00	+/-0.030	40.00	5		T	
41.88	+/-0.030	41.88	X		T	
43.63	+/-0.030	43.63	2		T	
0.125	+/-0.010	0.125	X		V B02	

<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-1-27	<b>Date:</b> 11/01/28	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

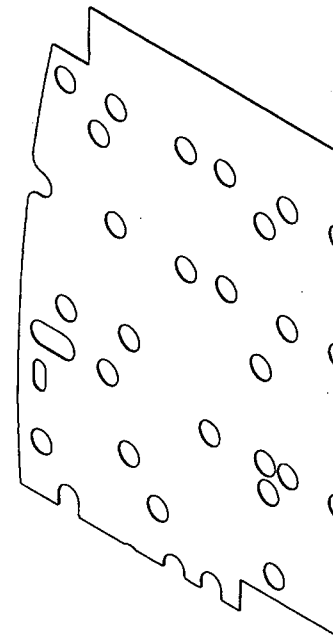
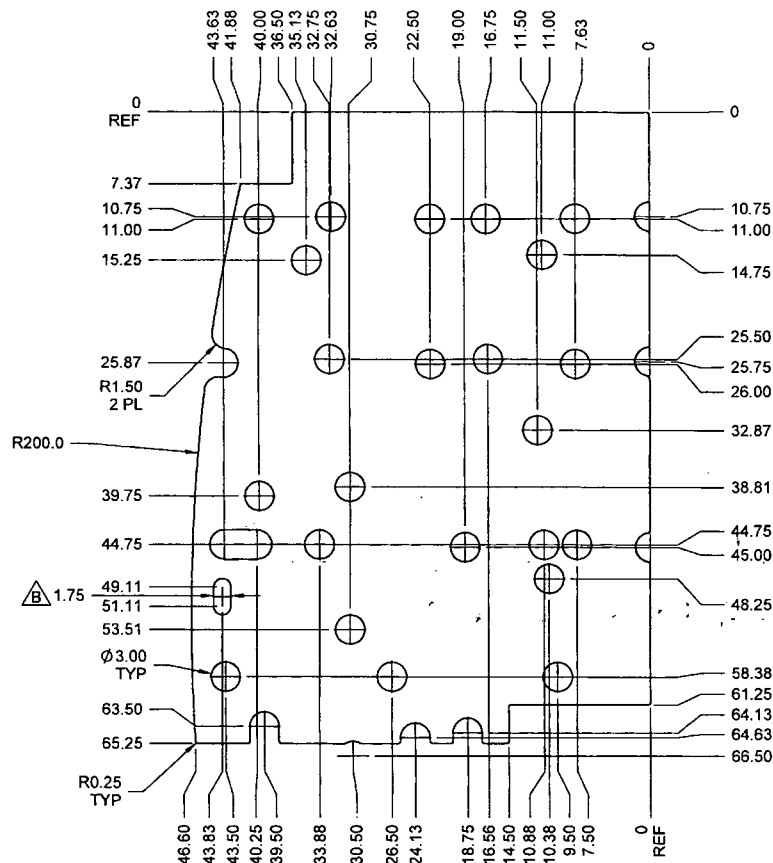
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 15945

RS 11-01-27



RELEASED  
09/04/07

### D3574-1 CABIN FLOOR PROTECTOR

#### NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

B	ADD CUT-OUT TO -14-5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5; -2 NOW SHOWN ON SHEET 2	<del>CB</del>	09.03.25
A	NEW ISSUE	CB	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.25		

DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3574	REV. 1 OF 1
TITLE CABIN FLOOR PROTECTOR	SCALE NT
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**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3574** REV. B  
SHEET 1 OF 6

TITLE **CABIN FLOOR PROTECTOR** SCALE  
NTS

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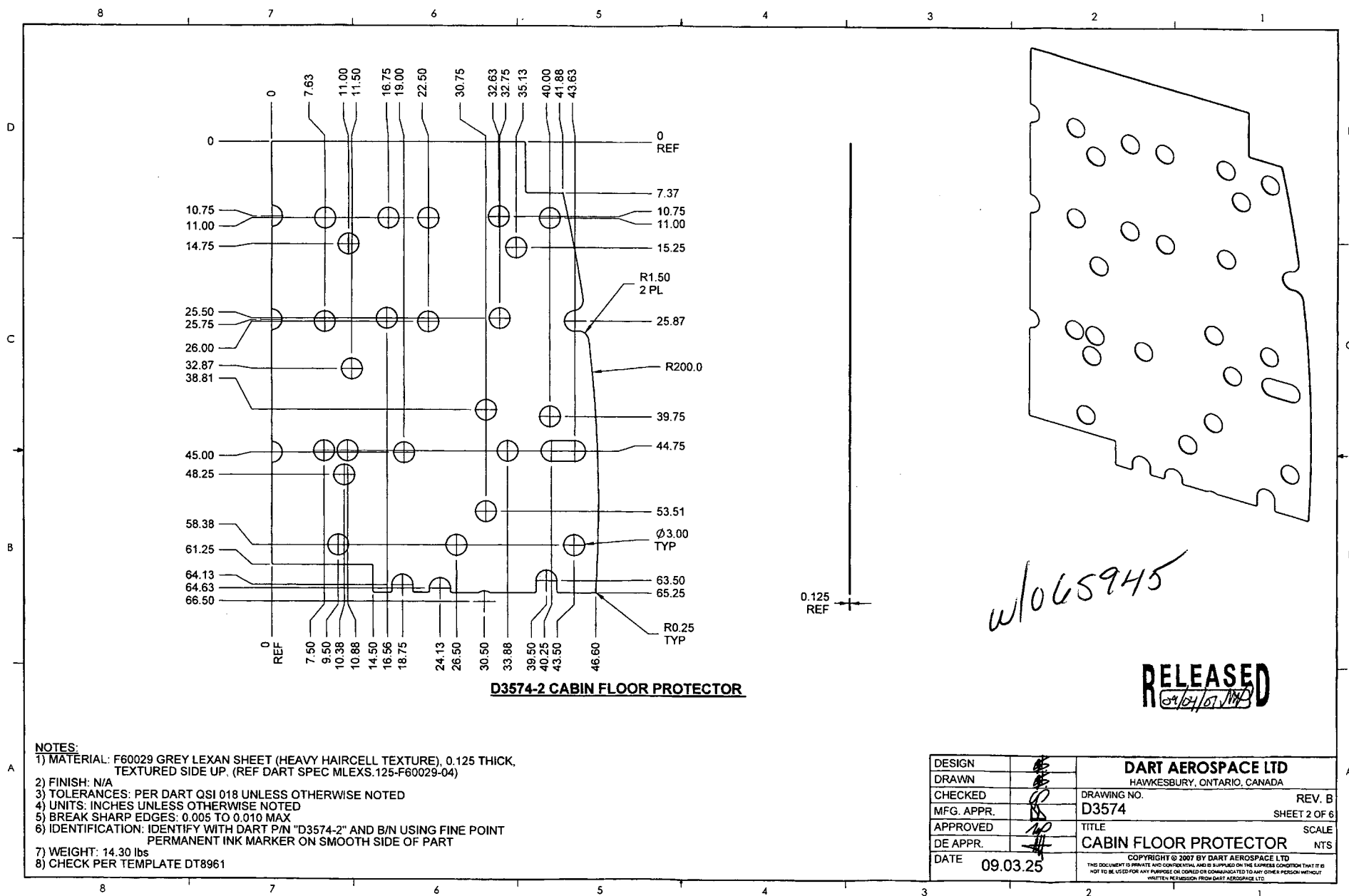
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

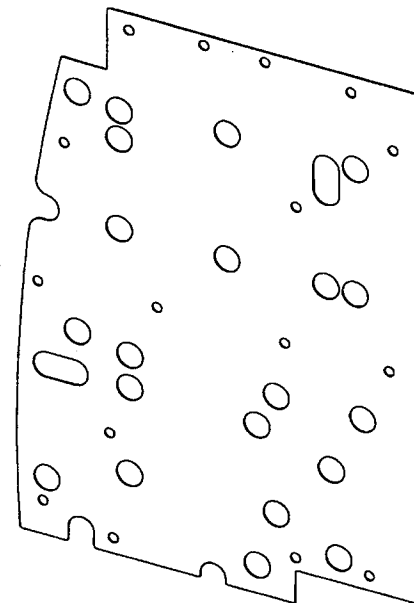
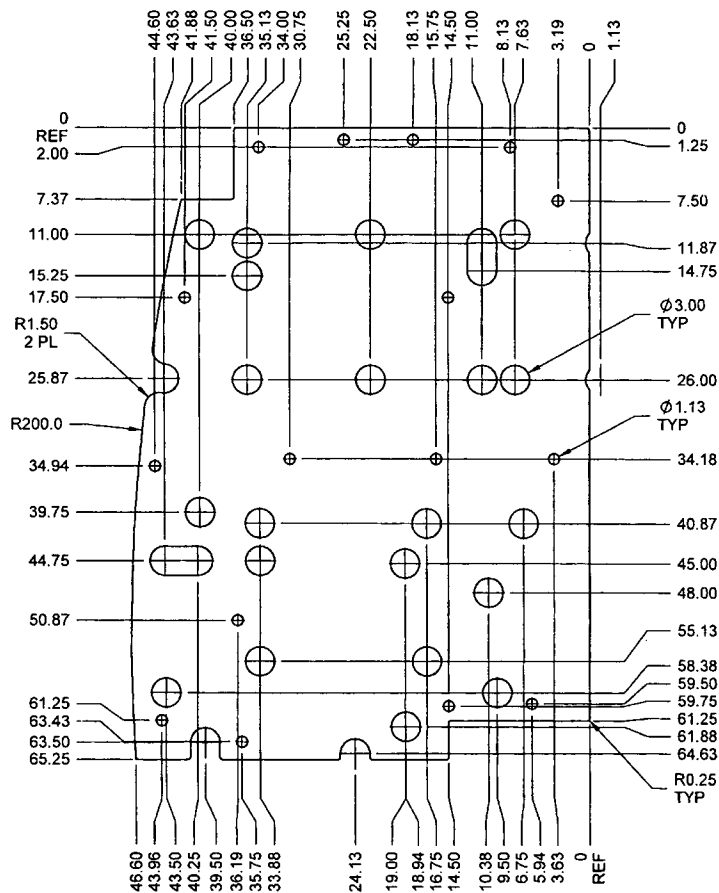
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries











W/O 65945

**RELEASED**  
09/24/07

### D3574-3 CABIN FLOOR PROTECTOR

#### NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.33 lbs
- 8) CHECK PER TEMPLATE DT8962

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3574	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
DATE	09.03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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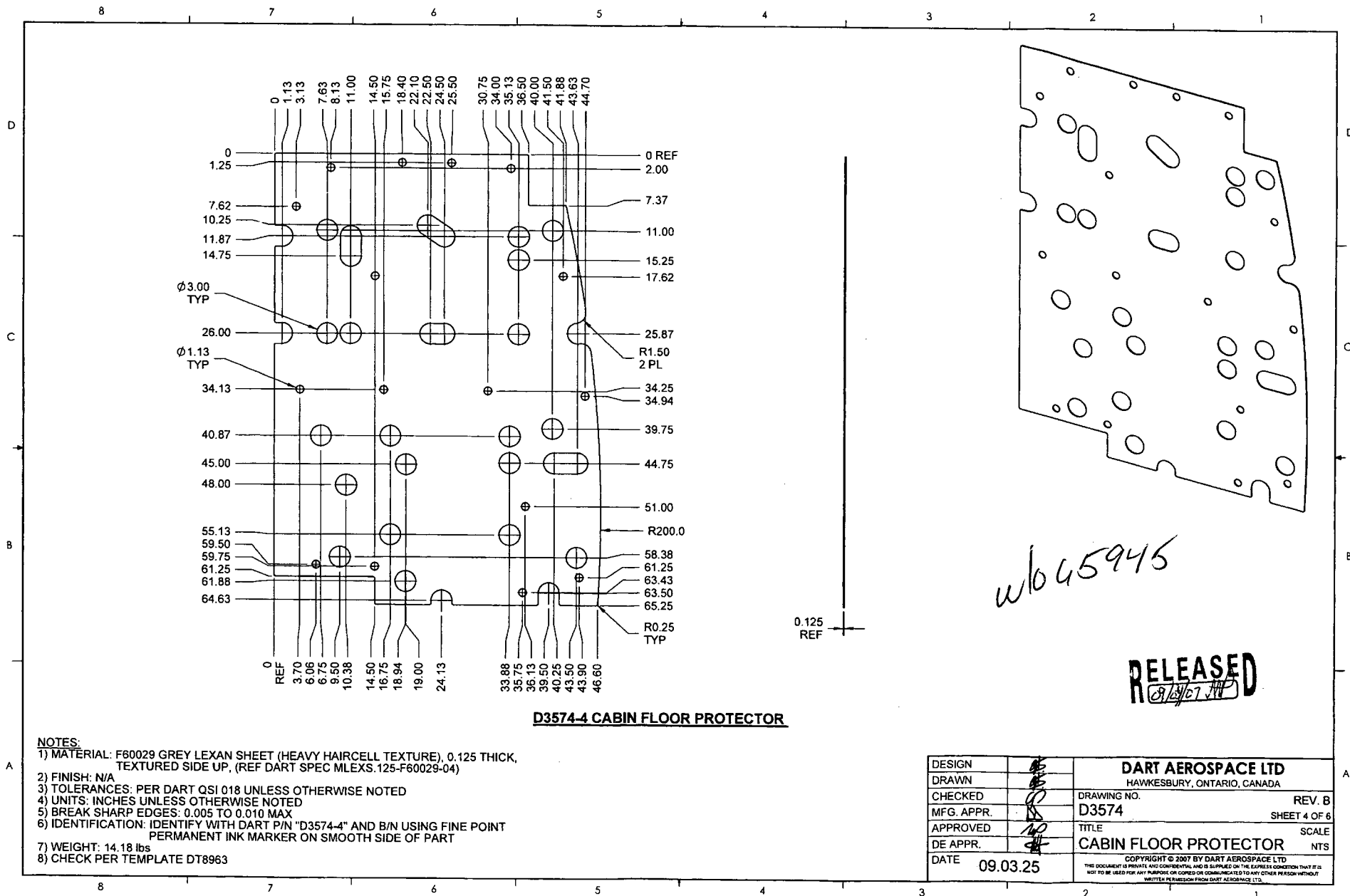
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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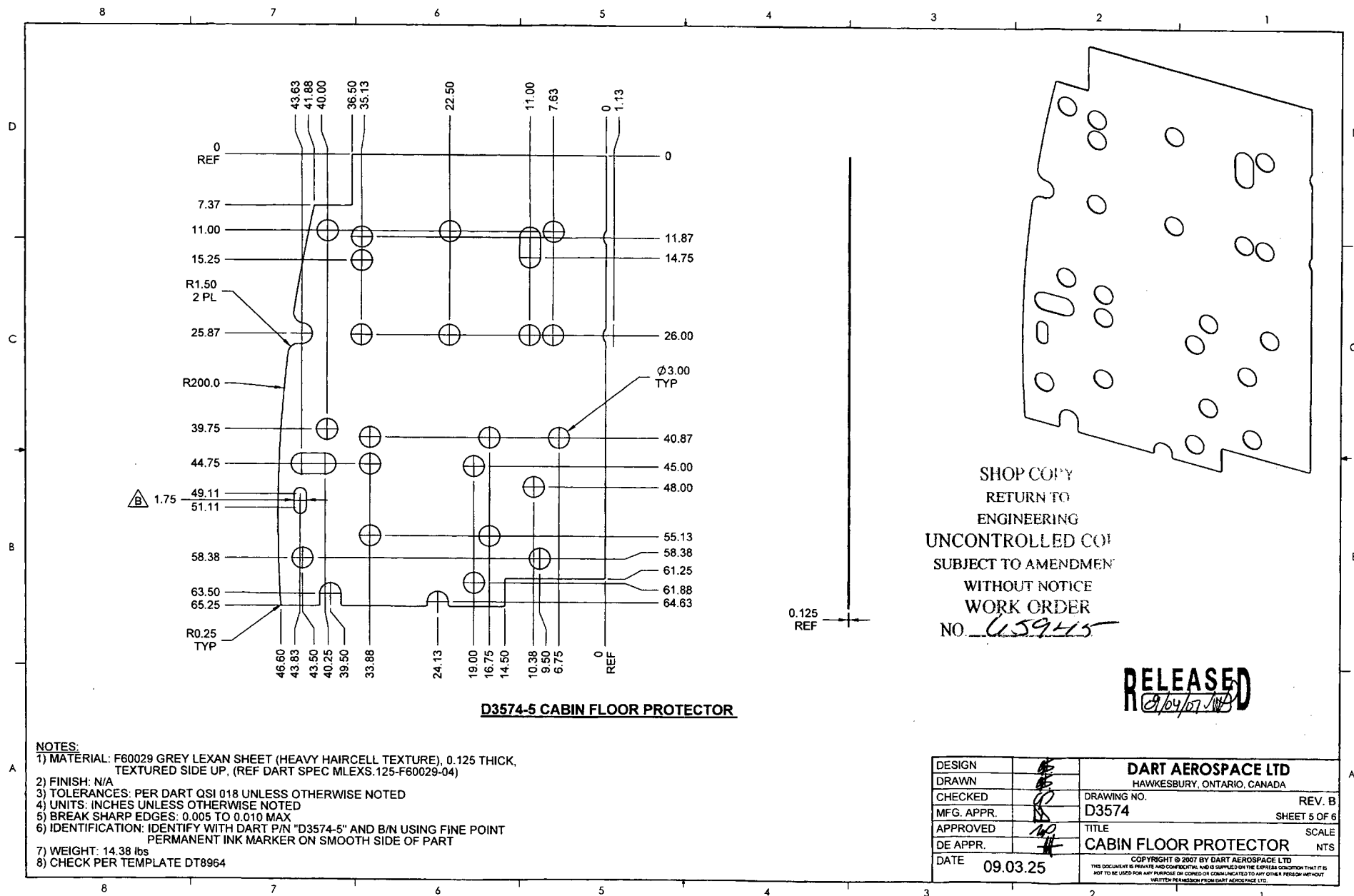
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